

**PATENT  
6990-1003**

C) predetermined regions of said one piece of metal later  
formed to include coined spacers surrounding each of said  
plurality of holes.

4/11  
CN 8. (Twice Amended) The chassis recited in claim 1 wherein said  
sides are inclined toward each other adjacent said top [edge].

8  
13. (Amended) An in-line skate having a chassis formed from a  
single piece of metal comprising:

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a chassis having a top portion, a bottom portion and  
two sides extending in a length direction;

footwear mounted to the top portion of the chassis;

a plurality of [coined] apertures formed and positioned  
in the bottom portion of the chassis along its length direction;  
[and having]

projections coined from said bottom portion of said  
single piece of metal surrounding said apertures and that extend  
from each side of the chassis toward the opposite side of the  
chassis; and

a plurality of wheels and axles rotatably mounted in  
the [coined] apertures and spaced between the two sides of the  
chassis by the projections.

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9.  
14. (Amended) An in-line skate chassis formed from a single piece of metal comprising:

a pair of sides including a first side, and a second side rigidly positioned substantially parallel to the first side;

a first plurality of [coined spacers] apertures formed in the first side and a second plurality of [coined spacers] apertures formed in the second side;

a [the] first plurality of spacers coined from the first side and extending from the first side toward the second side; and

a [the] second plurality of spacers coined from the second side and extending from the second side toward the first side.

11.  
15. (Amended) An in-line skate comprising:

a chassis, formed from a single piece of metal a plurality of wheels and axles rotatably mounted to a bottom part of the chassis, and footwear mounted on a top part of the chassis;

the chassis including a first side extending along a first direction and a second side extending in a direction substantially parallel to the first;

the first side including a plurality of first side holes formed in its bottom part;

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said first side holes being surrounded by a plurality of [coined] spacers [extending] coined from the first side and extending in a direction toward the second side;

the second side including a plurality of second side holes formed in its bottom part;

said second side holes being surrounded by a plurality of [coined] spacers [extending] coined from the second side and extending in a direction toward the first side;

said axles extending through said holes in said first side and said second side; and

said wheels mounted on said axles and spaced between said sides by said spacers.

Please add new claim 18 as follows:

~~18.~~ A method of making an in-line skate comprising:

providing a single piece of metal suitable for forming;

forming said piece of metal into a skate chassis having a top portion, a bottom portion and two sides extending in a length direction;

forming a plurality of apertures in the bottom portion of the chassis along its length direction;

coining a plurality of annular projections from said piece of metal in areas surrounding said apertures to form a plurality